

**Work Order ID 77087**

November-25-11 10:34:19 AM

**\*77087\***

Page 1

**Item ID:** D3245-7

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Gasket

Stop

**\*NS2\***

**Start Date:** 25/11/2011 **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date:** 09/12/2011 **Req'd Qty:** 8.00

**\*8\***

**Customer:**

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b> M.L.J	<b>Date:</b> 11/11/25	<b>Tooling:</b>	<b>Date:</b>	<b>Run</b>	<b>Start</b>	<b>*NR1*</b>
<b>QC:</b>		<b>Date:</b>	<b>SPC (Y/N):</b>	<b>Date:</b>	<b>Stop</b>		<b>*NR2*</b>

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
----------------------------------------	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3245	Rev B

100 0.00

**\*100\*** FLOW WATER JET

Waterjet

**Memo** 0.00

FLOW CNC Waterjet I-Cut as per Dwg D3245 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

11/11-29

(10)

110 0.00

**\*110\***

QC

Quality Control

**Memo** 0.00

11/11-29

120 0.00

**\*120\***

QC

Quality Control

**Memo** 0.00

n 11.11.30 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

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Page 2

**Item ID:** D3245-7

Accept

**\*N900040100\***

Setup

Start

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**Revision ID:**

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**Start Date:** 25/11/2011 **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date:** 09/12/2011 **Req'd Qty:** 8.00

**\*8\***

**Customer:**

**Reference:**

**Approvals:** Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Locations

*ST233B*

0.00

**\*130\***

Packaging

Memo

0.00

*Sp 11-11-30.*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

*11/11/30*

Quality Control

*MK*  
*11-11-30*

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NOTE: Date & initial all entries

# Picklist Print

November-25-11 10:34:23 AM

Page 1

Work Order ID: 77087

\*77087\*

Parent Item: D3245-7

\*D3245-7\*

Parent Item Name: Gasket

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C04.11.17 Made in-house KJ/JLM  
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245		Manufactured	No			100	Each	24.7140	1	8	10	8	10

\*D3245\*

Gasket

Location	Loc Qty	Loc Code
MAT051	24.714	
69232	24.714	69032

(10)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77087
Description: Gasket	Part Number:	D3245-7
Inspection Dwg: D3245	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

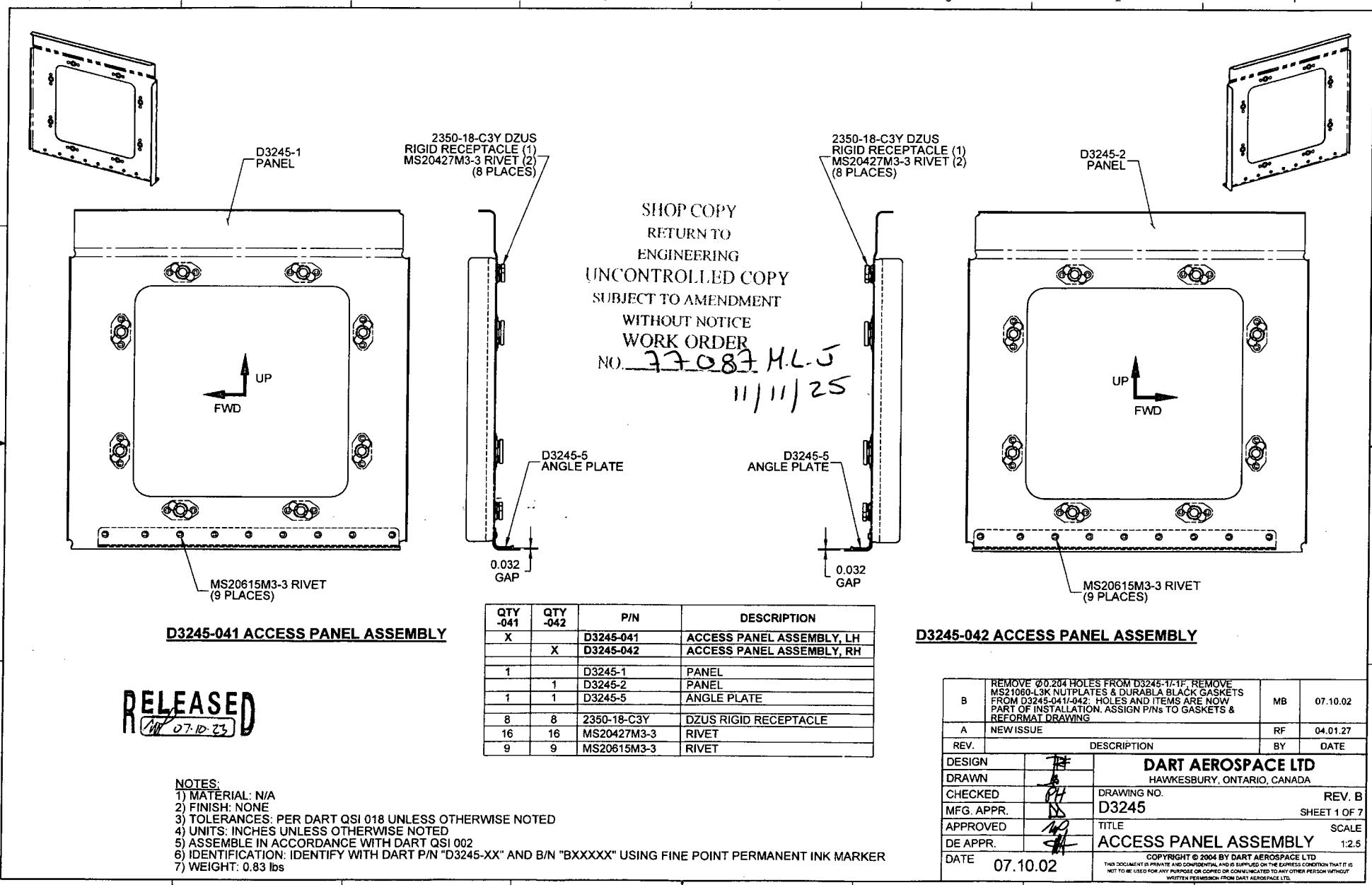
Measured by:	R	Audited by:	W/W	Prototype Approval:	N/A
Date:	11-11-29	Date:	11-11-30	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	09.05.04	New Issue		KJ/DD	

W/O:		WORK ORDER CHANGES						
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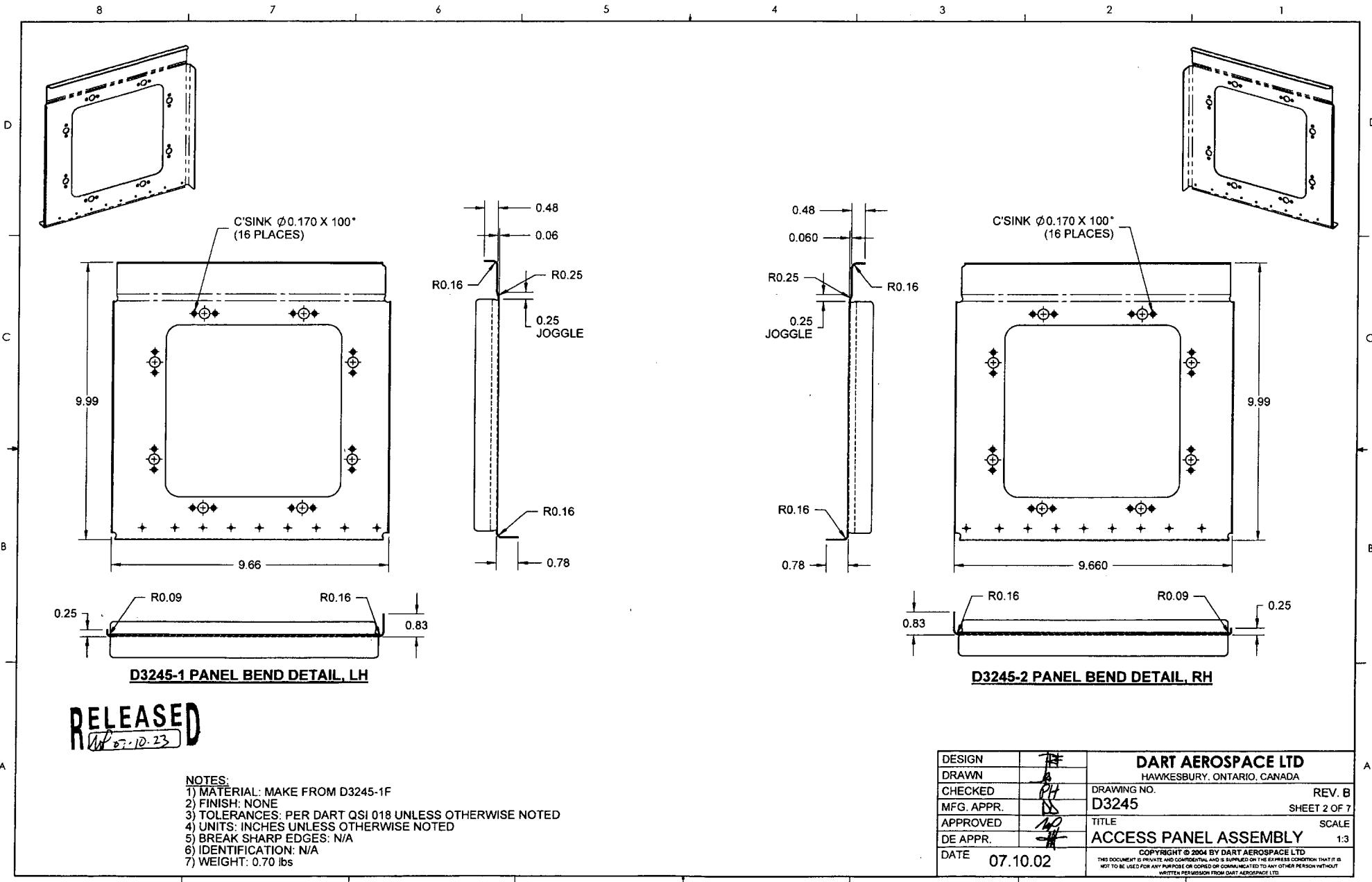
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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770 87



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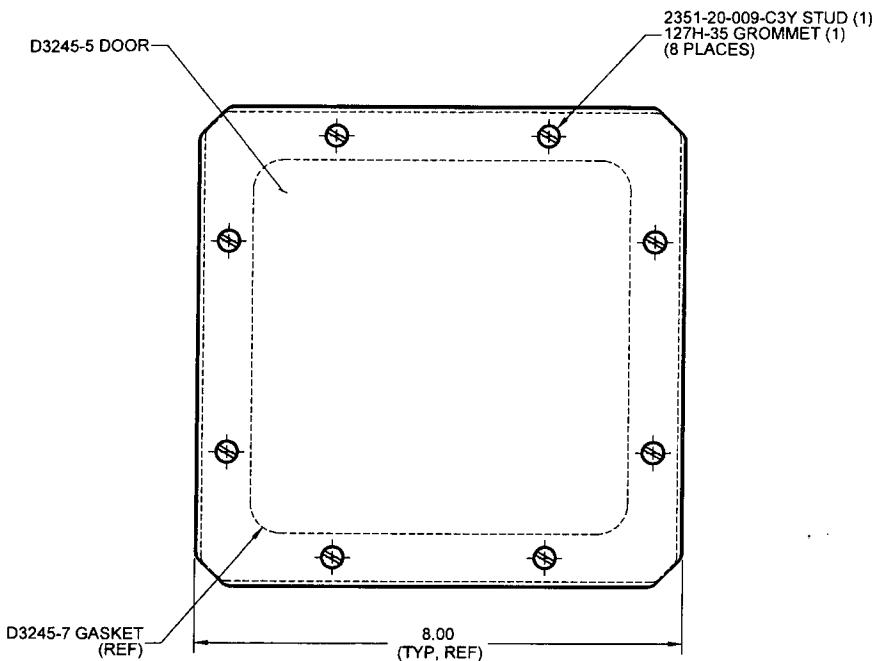
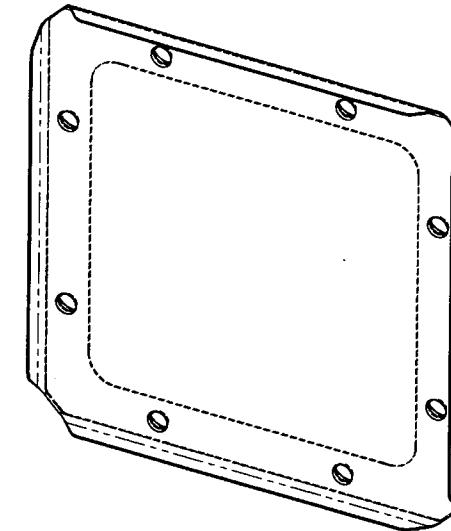
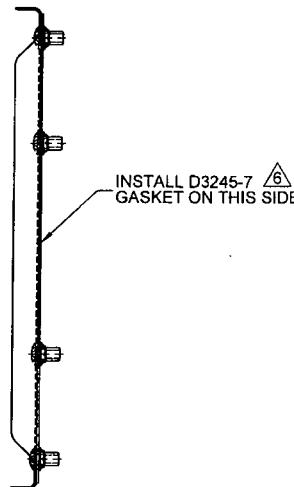
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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77087

8 7 6 5 4 3 2 1

**D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

RELEASED  
MM 27.10.02

DESIGN	PF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JB	DRAWING NO. <b>D3245</b>
CHECKED	PH	REV. B
MFG. APPR.	DS	SHEET 3 OF 7
APPROVED	MP	TITLE
DE APPR.	SH	SCALE
DATE	07.10.02	ACCESS PANEL ASSEMBLY

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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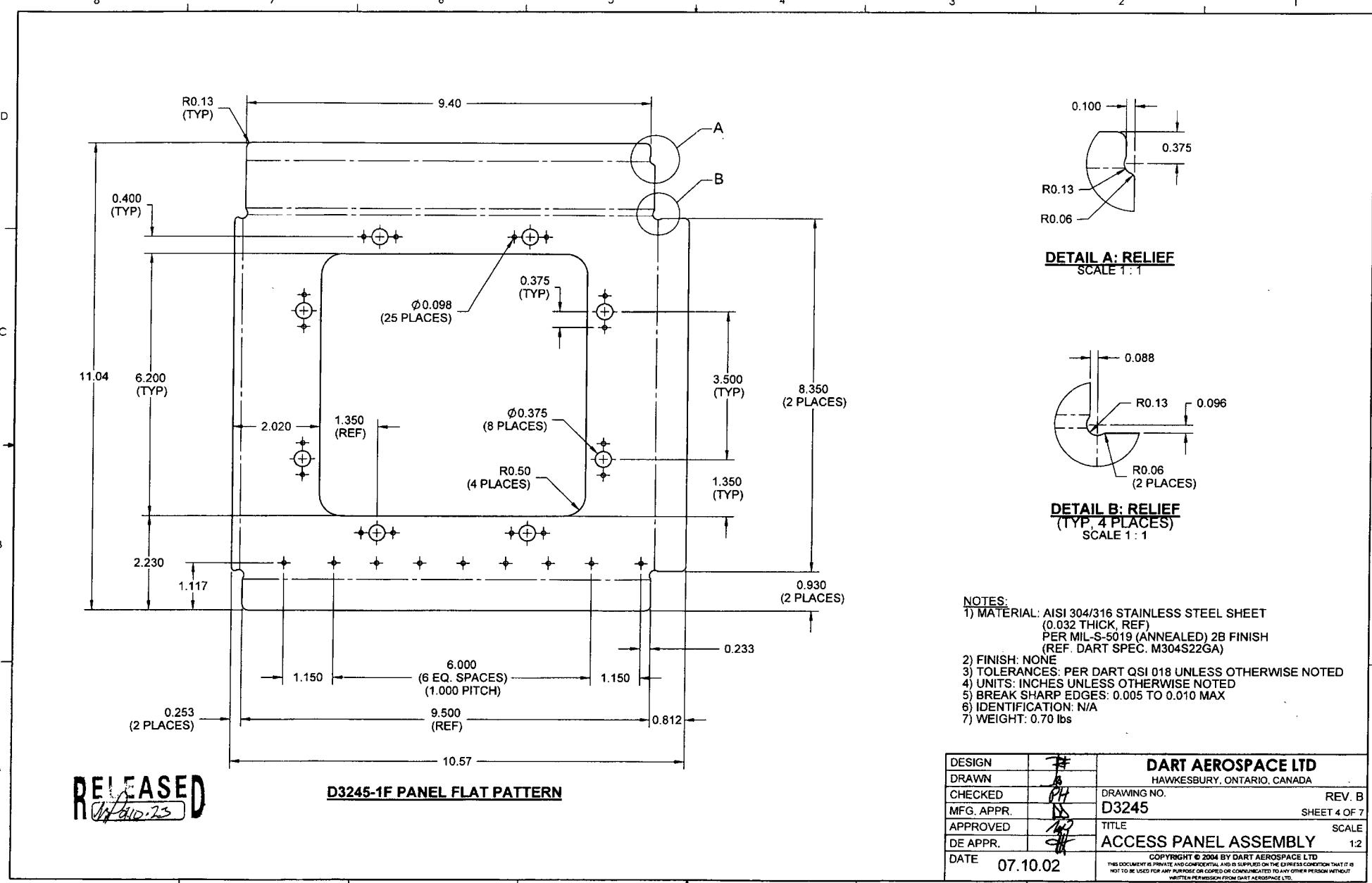
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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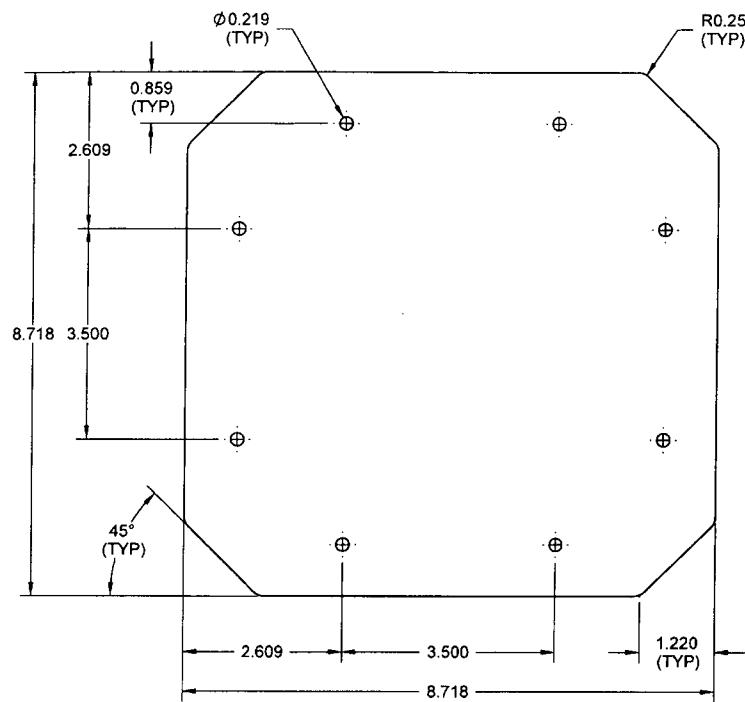
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77087

8 7 6 5 4 3 2 1

D



D3245-3F DOOR FLAT PATTERN

RELEASED  
(IN 07.10.02)

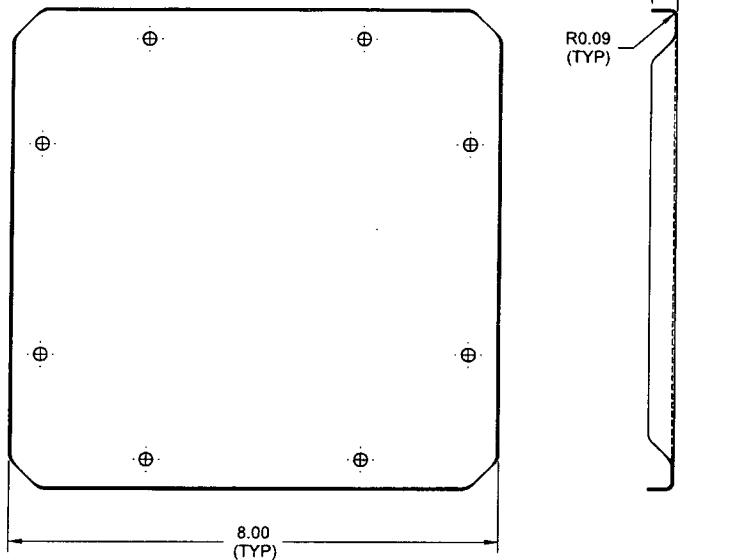
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NOTES:

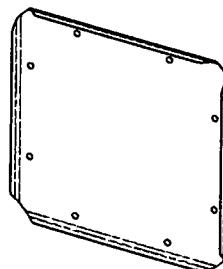
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

8 7 6 5 4 3 2 1

D



D3245-3 DOOR BENDING DETAIL



DESIGN	77	DART AEROSPACE LTD
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	ND	REV. B
APPROVED	AD	SHEET 5 OF 7
DE APPR.	SH	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 1:2

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8 7 6 5 4 3 2 1

A

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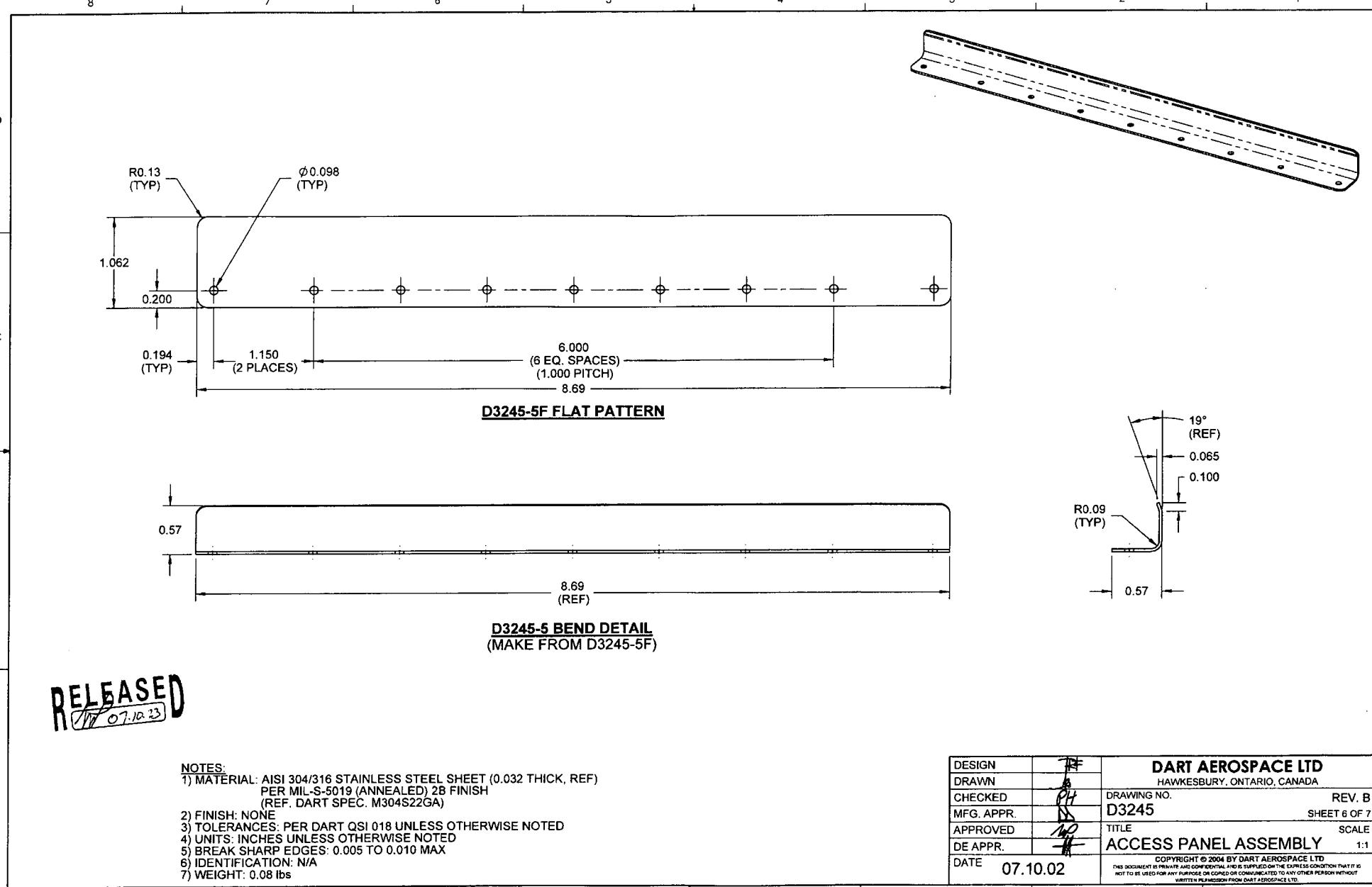
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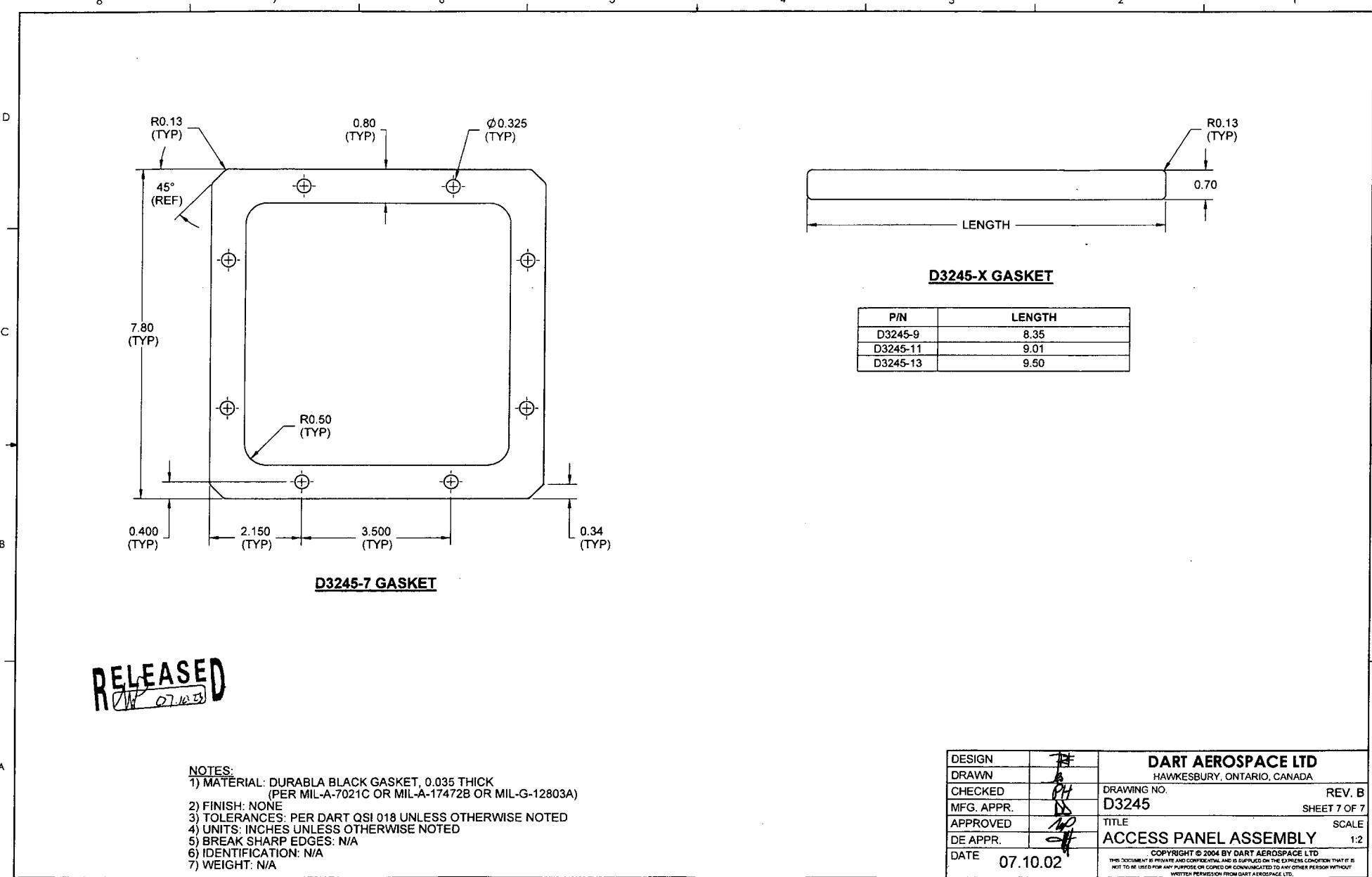
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